

shy April 13

Work Order ID 81409

81409

Page 1

March-14-12 7:50:27 AM

Item ID: D4030-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

① SP12-04-03.

EP 12/04/04 ①

④

Sizley

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81409***81409***

Page 2

March-14-12 7:50:28 AM

Item ID: D4030-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

PDP 81767

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/5 d
mf
12-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

March-14-12 7:50:31 AM

Page 1

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4086-210 200

Manufactured

No

Each

5.0000

1

D4086-210

Placard, Max Load

**

*

B72051 SP

Location

Loc Qty

Loc Code

ST122

4

66275

1

76298

3

ST124

1

64869

1

D2530

Manufactured

No

100

Each

9.0000

1

1

D2530

Handle Weldment

**

SP

Location

Loc Qty

Loc Code

ST506

9

77030

3

78965

6

D2535

Manufactured

No

100

Each

44.0000

2

2

D2535

Spring

**

SP 12-04-03

Location

Loc Qty

Loc Code

ST504

44

77488

44

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each 34.0000 2 2

D2537

Bushing

**

88

Location

Loc Qty

Loc Code

ST504

34

77055

34

D3913-041

Manufactured No

100 Each 0.0000 1 1

D3913-041

Long Basket Base Assembly, 350

D3914-041

Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

100 Each 19.0000 6 6

D3917-3

Washer

**

B8120588

Location

Loc Qty

Loc Code

ST070

19

76956

4

80598

15

D3953-3

Manufactured No

100 Each 26.0000 2 2

D3953-3

Gas Spring Stud, Lid

**

88 12-04-03

Location

Loc Qty

Loc Code

ST075

26

76659

6

78042

20

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each 14.0000 2 2

D3953-7

Spring Spacer

**

SP

Location

Loc Qty

Loc Code

ST075

14

76295

14

2X

D3953-9 Manufactured No

100 Each 18.0000 2 2

D3953-9

Gas Spring Washer

**

SP

Location

Loc Qty

Loc Code

ST075

18

78916

18

2X

D3953-17 Manufactured No

100 Each 7.0000 2 2

D3953-17

Gas Spring Spacer

**

B8/454 SP

Location

Loc Qty

Loc Code

ST075

7

76294

7

D3953-19 Manufactured No

100 Each 14.0000 1 1

D3953-19

Gas Spring Bracket

**

SP

Location

Loc Qty

Loc Code

ST075

14

75227

14

1X

D3953-21 Manufactured No

100 Each 1.0000 1 1

D3953-21

Gas Spring Bracket

**

B8/207
SP 12-04-03

Location

Loc Qty

Loc Code

ST075

1

73557

1

March-14-12 7:50:31 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

15.0000

1

D3969-3

Spring (Basket Lid)

**

381887 SP

Location

Loc Qty

Loc Code

ST272

15

64285

1

73515

14

AN3-14A

Purchased No

100

Each

96.0000

4

4

AN3-14A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST352

96

119328

96

AN3-16A

Purchased No

100

Each

137.0000

2

2

AN3-16A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST352

137

117441

49

118628

38

120986

50

AN5-17A

Purchased No

100

Each

84.0000

4

4

AN5-17A

Bolt

**

SP 12-04-03

Location

Loc Qty

Loc Code

ST338

84

117872

42

120498

42

4x

March-14-12 7:50:32 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 5

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 89.0000 3 3

AN4-12

Bolt

**

SP

Location

Loc Qty

Loc Code

ST357

89

118626

14

119775

25

120986

50

AN310-4 Purchased No

100 Each 75.0000 3 3

AN310-4

NUT

**

SP

Location

Loc Qty

Loc Code

ST344

75

120124

25

120518

25

121011

25

AN310C4 Purchased No

100 Each 49.0000 2 2

AN310C4

Nut

**

SP 12-04-03.

Location

Loc Qty

Loc Code

ST344

49

119324

19

120360

30

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

March-14-12 7:50:32 AM

Page 6

Work Order ID: 81409

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

81409

D4030-041

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

3,192.000

6

6

MS21042I 3

Nut

**

Sp

Location

Loc Qty

Loc Code

ST300

3192

117441

16

117885

32

118451

5

118927

3

119017

2956

119075

180

Lex

MS21042L5

Purchased

No

100

Each

1,618.000

4

4

MS21042I 5

Nut

**

Sp

Location

Loc Qty

Loc Code

ST300

1618

116105

5

116548

43

117611

42

118179

28

119109

1500

4x

MS24665-151

Purchased

No

100

Each

315.0000

3

3

MS24665-151

Cotter Pin

**

Sp 12-04-03

Location

Loc Qty

Loc Code

ST309

315

17566

315

3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:50:32 AM

Page 7

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

210.0000

2

2

MS24665-300

Cotter Pin

**

SP

Location

Loc Qty

Loc Code

GA

200

118234

200

2x

ST309

10

116823

10

NAS1149F0432P

Purchased

No

100

Each

298.0000

6

6

NAS1149F0432P

Washer

**

MD1060SP.

Location

Loc Qty

Loc Code

ST275

298

118840

32

119307

64

120142

2

120360

200

NAS1149F0563P

Purchased

No

100

Each

93.0000

4

4

NAS1149F0563P

Washer

**

SP12-04-03.

Location

Loc Qty

Loc Code

ST275

93

117735

93

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

March-14-12 7:50:32 AM

Page 8

Work Order ID: 81409

81409

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

782.0000

8

8

NAS1149F0332P

**

WASHER

m/21/66 SP.

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

142

120498

200

120910

200

120986

200

17317

3

NAS1149C0432R

Purchased

No

100

Each

2,618.000

2

2

NAS1149C0432R

**

Washer

SP/2-04-08.

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

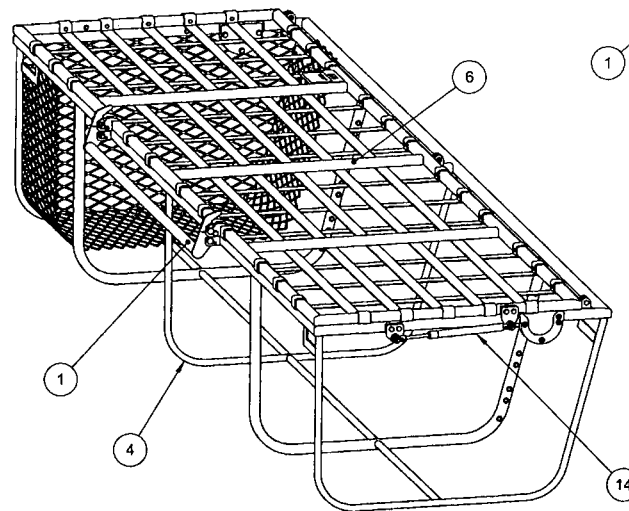
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

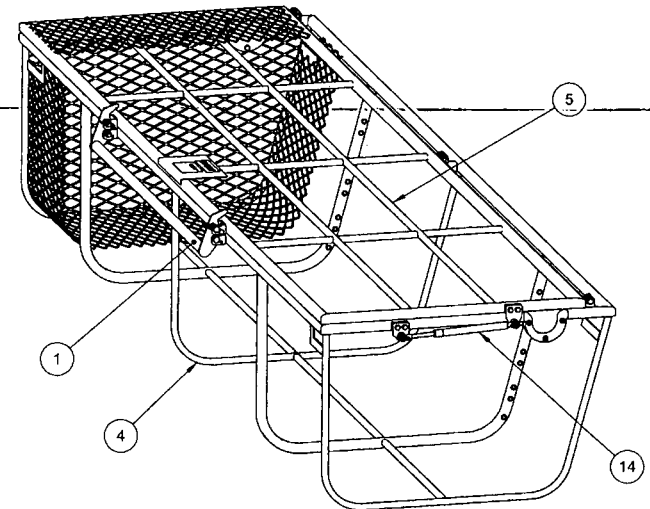
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY	QTY	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81409 *MLJ*
12/03/14

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10-08-12-04
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1); ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>JPH</i>		
CHECKED	<i>JPH</i>		
MFG. APPR.	<i>JPH</i>		
APPROVED	<i>JPH</i>		
DE APPR.	<i>JPH</i>		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. C
SHEET 1 OF 3
TITLE **LONG BASKET ASSY (350)** NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

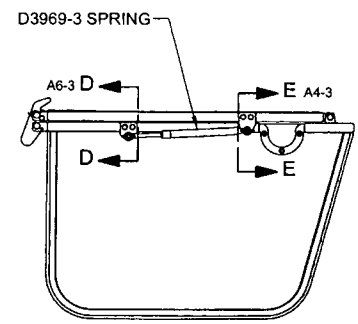
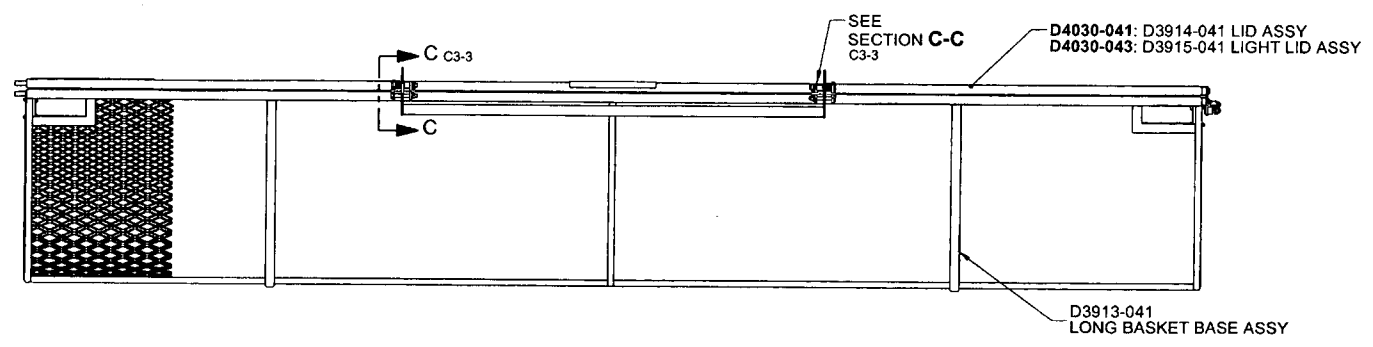
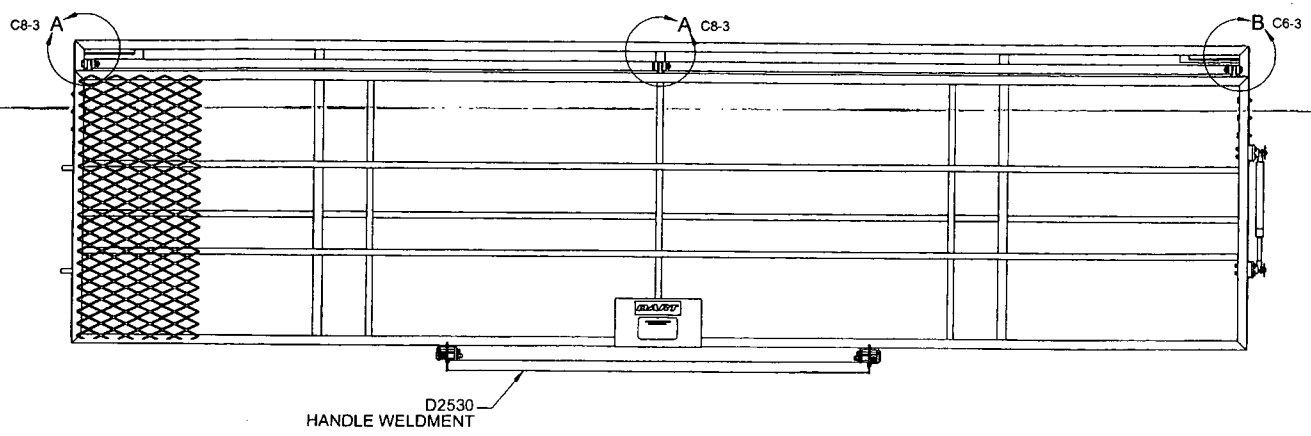
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81409



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	SES B.L.	D4030	SHEET 2 OF 3
APPROVED	h	TITLE	SCALE
DE APPR.	h	LONG BASKET ASSY (350) _____ NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

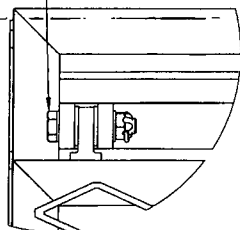
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

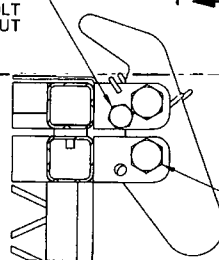
81409

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

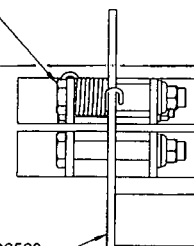
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

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MFG. APPR.	T.F.S. J.L.A.	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries